

Date: Thursday, 3/30/2006 10:05:48 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT
Job Number	: 26445	Part Number	: D2565103
Estimate Number	: 10275	Drawing Number	: D2565 REV E
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 3/30/2006	Drawing Revision	: E
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 4/15/2006
Previous Run	: 25972	Qty:	20
Written By	<u>SAC FOR COMMENT Below</u>		
Checked & Approved By	<u>KJ 06.03.30</u>		
Comment	: Est: F02.04.08 Added dwg Rev.C1 NG		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
		Comment: Qty.: 1.5934 f(s)/Unit Total : 31.8675 f(s) 304 RD TUBE .750 X.49W 304/316/318-2B Seamless Tubing, 3/4" O.D. x 0.049" wall (M304TR0750W049) Batch <u>11100540</u>	
2.0	BRAKE NC	NC BRAKE	
		Comment: BRAKE NC Punch to length as per Dwg D2565 using DT8313	
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Drill hole open to .316 Ø as per Dwg D2565 (one end only) 2-Deburr	
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	
5.0	POWDER COATING	POWDER COATING	
		Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/05/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STRUT

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

104/5/08 (20)

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 185

AP 06/05/08 20

8.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/05/08 (20)

Job Completion



104/5/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

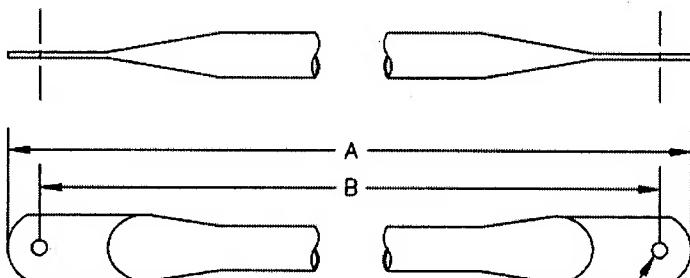


A circular stamp with the words "COPY ISSUED" printed around its perimeter.

DESIGN <del>#</del>	DRAWN BY <del>JM</del>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <del>#</del>	APPROVED <del>JM</del>	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05	TITLE STRUT		SCALE -1:3

RELEASED  
04 05 05 - #

A	96.05.03	NEW ISSUE
B	97.03.15	CORRECT D2565-111 DIM. A
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)
D	02.06.05	ADD -3XX PARTS; ADD FINISH
E	04.05.05	ADD D2565-401-411; RMV ANGLE D



DIA 0.257 TO BE PUNCHED  
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

## GENERAL NOTES

**NOTES**

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
(REF DART SPEC. M304TR0.750W0.049)  
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTE
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY

**RETURN TO**

## ENGINEERING

## CONTROLLED

UNCONTROLLED COPY

**SUBJECT TO AMENDMENT**

**WITHOUT NOTICE**

WORK ORDER

NO. 2045

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